

Work Order ID 92884

92884

Page 1

Friday, November 09, 2012-3:51:21 PM

Item ID: D139-799-112

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step w/ Grab Bar, RH

Start Date: 11/9/2012 Start Qty: 3.00

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 3.00

Customer:

Reference: REWORK PER ECM 12-660

Approvals: Process Plan: MF

Date: 12-11-09 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D139-799	G

150

0.00

150

Mill Conv

Conventional Milling Machine

Memo

0.00

PULL FROM STOCK D139-799-112 X 3:

1 X B82572

2 X B85720

REMOVE D4526-042 X 3 AND DISSASSEMBLE TO REWORK PARTS
D4527-1/3 PER NEW DRAWING REV B

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Quality Control

Memo

0.00

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PN	D139-799-112	CHG	CHG001		
DESC	Maintenance Step	STC	SR02138SE		
LOT	B85720	STC			
MODEL	Agusta AB/AW139	STC			
MADE IN CANADA					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PN	D139-799-112	CHG	CHG001		
DESC	Maintenance Step	STC	SR02138SE		
LOT	B85720	STC			
MODEL	Agusta AB/AW139	STC			
MADE IN CANADA					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PN	D139-799-112	CHG	CHG001		
DESC	Maintenance Step	STC	SR02138SE		
LOT	B82572	STC			
MODEL	Agusta AB/AW139	STC			
MADE IN CANADA					

Work Order ID 92884

92884

Page 2

Friday, November 09, 2012 3:51:21 PM

Item ID: D139-799-112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Maintenance Step w/ Grab Bar, RH
Start Date: 11/9/2012 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/16/2012 Req'd Qty: 3.00 ***3*** Customer:
Reference: REWORK PER ECN 12-660

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Touch up alodine	0.00							
170						3	26	12/1/14	
HandFinish	Memo	0.00							
Hand Finishing	TOUCH UP WITH ALODINE D4527-1/3 ON REWORKED AREA								
180	QC7-Inspect Chemical Conversion Coat	0.00							
180						3			
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
Small Fab	Memo	0.00							
Small Fab	RE-ASSEMBLE KIT								

3X

use MS 24684-555 that are still in good condition - replace the rest with new batch number.

12/11/20

Work Order ID 92884

Friday, November 09, 2012 3:51:21 PM

92884

Page 3

Item ID: D139-799-112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Maintenance Step w/ Grab Bar, RH
Start Date: 11/9/2012 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/16/2012 Req'd Qty: 3.00 ***3*** Customer:
Reference: REWORK PER ECN 12-660

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				3			
210 *210* Packaging Packaging	Pick Kit Memo REMOVE FROM KIT AN6H12 X 12 AND RETURN TO STOCK B <u>12340</u> REPLACE WITH: AN6H12A X 2 PER KIT B <u>123556</u> AN6H13A X 2 PER KIT B <u>123556</u> PER ECN 12-660 ID AND STOCK UNDER NEW BATCH NUMBER AT CHANGE 002	0.00 0.00							

[Handwritten signature]

Work Order ID 92884***92884***

Page 4

Friday, November 09, 2012 3:51:21 PM

Item ID: D139-799-112

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step w/ Grab Bar, RH

Start Date: 11/9/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 3.00

3

Customer:

Reference: REWORK PER ECN 12-660

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MC5 12-11-20

MF
12-17-21

Picklist Print

Friday, November 09, 2012 3:51:21 PM

Page 1

Work Order ID: 92884

Parent Item: D139-799-112

Parent Item Name: Maintenance Step w/ Grab Bar, RH

Start Date: 11/9/2012

Required Date: 11/16/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6H12 Bolt		Purchased	No				Each	16.0000		-12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST341		16							
				121340		16							
AN6H12A Bolt		Purchased	No				Each	50.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		50							
				123556		50							
AN6H13A Bolt		Purchased	No				Each	30.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST339		30							
				123556		30							
D139-799-112 Maintenance Step w/ Grab Bar, RH		Manufactured	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				80561		1							

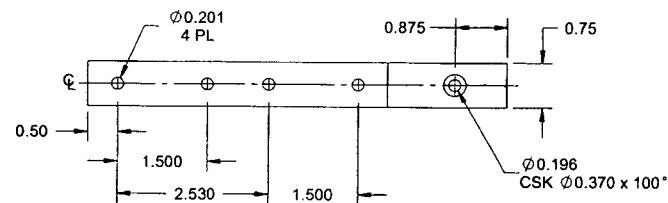
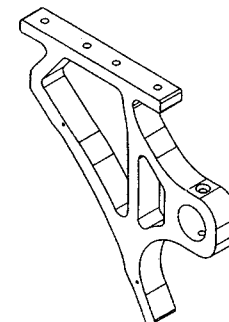
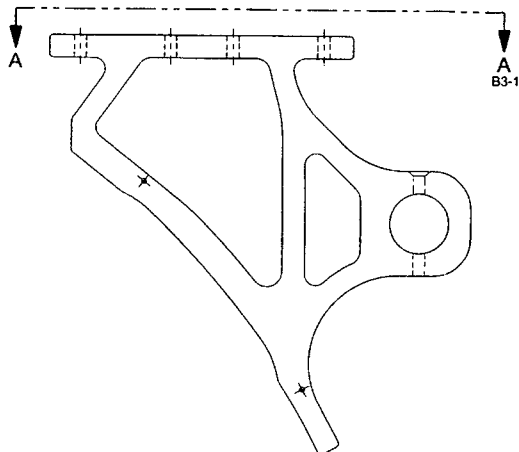
85720
82572

M 123758
M 121349
M 122973
M 122452

2
1 12-11-14

24
6
30
30
SP
12/11/20

MS24694S55
MS24694S75
NAS1149 DD332J
MS21042L3



SECTION VIEW A-A D6-1

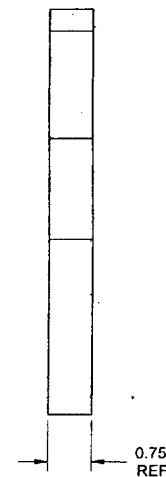
RELEASED
2012-10-31
MD

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lbs

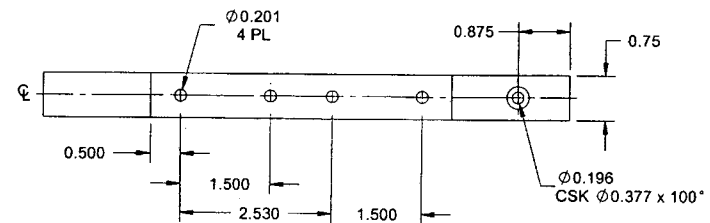
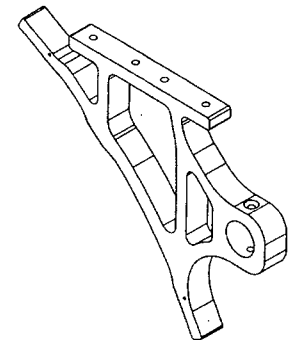
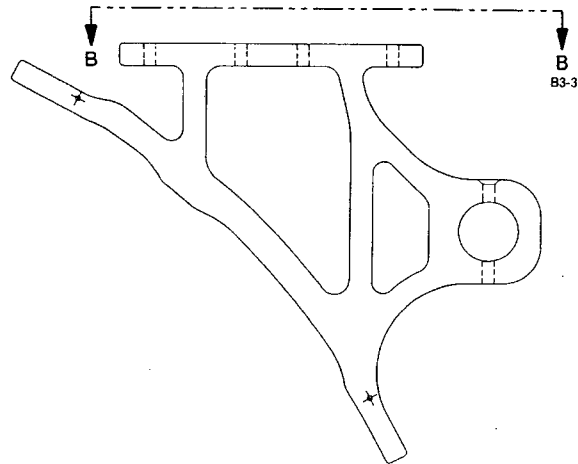
D4527-1 BRACKET

B	ADD Ø0.080 HOLES (ZN B5-2, B5-4)	RF	12.09.18
A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4527	SHEET 1 OF 4
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
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RELEASE
2012-10-31
md

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SECTION VIEW B-B B5-3

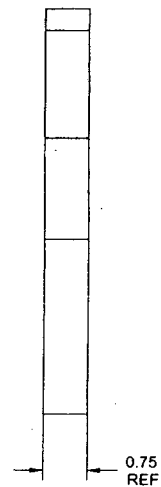
D4527-3 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.90 lbs

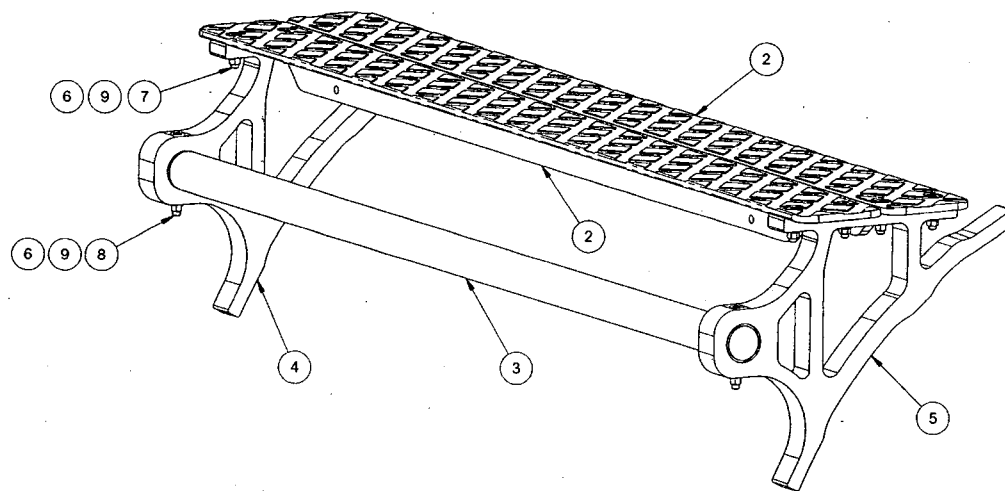
RELEASED
2012-10-31

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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2012-10-31

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DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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D4526-042 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

use original good condition

RELEASED
2011-11-28
MS

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

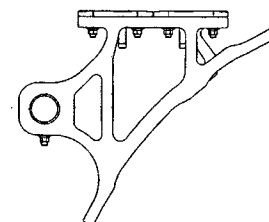
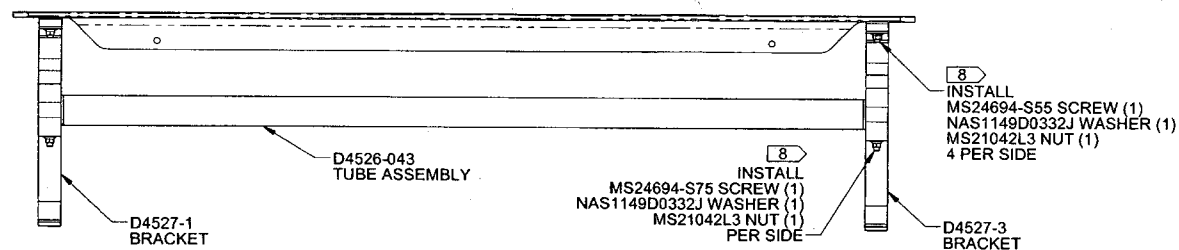
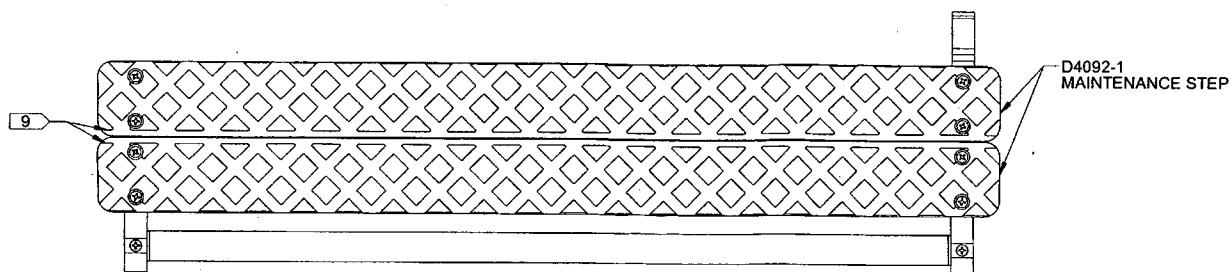
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



D4526-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
R 2011-11-28
JWP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4526	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	
DATE	11.11.22	NTS	

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		